

Work Order ID 78237

January-02-12 4:00:24 PM

78237

Page 1

Item ID: D2572 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd In 205
 Start Date: 02/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 20/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2572	Rev E								

100 0.00
100 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 Program Batch No. 78237
 Double check by: FR
 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and insp

OK 12/01/21
B.A 12/01/24

12 0

110 0.00
110 CONVENTIONAL MILLING MACHINE
 Mill Conv Memo 0.00
 Conventional Milling Machine Machine keyway as per dwg D2571 & D2572

B.A 12/01/24

12 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78237

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Page 2

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Item ID: D2572 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd In 205
 Start Date: 02/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 20/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>over 12/01/21</i>			<u>12</u>	<u>0</u>		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>12/01/24</i> <i>29 12-1-25</i>			<u>12</u>	<u>1</u>		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>12</u>	<u>BL 12-1-25</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

78237

January-02-12 4:00:24 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 02/01/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 20/01/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

170

Identify as per dwg & Stock Location: 433

0.00

170

Packaging

Packaging

Memo

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 78237***78237***

Page 4

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Item ID: D2572

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd In 205

Start Date: 02/01/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 20/01/2012 Req'd Qty: 12.00

12

Customer:

Reference:

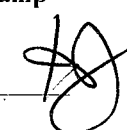
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/26 MF
12-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 1

January-02-12 4:00:28 PM

Work Order ID: 78237

78237

Parent Item: D2572

D2572

Parent Item Name: Saddle, Fwd In 205

Start Date: 02/01/2012

Required Date: 20/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	56.0000	1	12			
D6101-005									**				

Saddle Billet

Location

Loc Qty

Loc Code

MAT041

51

- 71721

1

~~7~~ 6838

50

MAT045

1

74507

1

MAT046

4

66966

3

74507

1

12

sub 12/01/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78237
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.446	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.002	8.001	8.002		
F	0.490	0.510		.502	.501	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.499	.500	.499		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.567	.567		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.874	3.874	3.874		
P	0.115	0.135		.126	.127	.127	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.251	.250	.250		
S	0.115	0.135		.126	.126	.127	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.957	2.957	2.957	2.957		
V	0.230	0.250		.236	.238	.240	.242		
W	0.115	0.135		.120	.121	.127	.127		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		.366	.366	.369	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.624	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.246	.247	.248		
AE	1.375	1.395		1.390	1.390	1.387	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.255	.255	.255		
AH	0.240	0.260		.244	.245	.247	.249		
AI	2.000	2.020		2.006	2.006	2.004	2.002		
AJ	0.023	0.043							
Accept/Reject									

Measured by:	amf	Da
Date:	12/01/21	12/01/24

Audited by:	RQ
Date:	12.1.25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 78237
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				X5	X6	X7	X8		
A	0.438	0.443		.440	.440	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.500	.500	0.500	0.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.499	.500	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.251	.251		
S	0.115	0.135		.133	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.957	2.957	2.957	2.957		
V	0.230	0.250		.243	.242	.242	.241		
W	0.115	0.135		.126	.127	0.127	0.127		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		.366	.368	0.367	0.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.624	0.625	0.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	.247		
AE	1.375	1.395		1.384	1.385	1.386	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.258	.260	.250	.255		
AH	0.240	0.260		.251	.249	.250	.250		
AI	2.000	2.020		2.002	2.002	2.000	2.002		
AJ	0.023	0.043							
Accept/Reject									

Measured by: <i>mf</i>	A.A.
Date: 12/01/23	12/01/24

Audited by: <i>RF</i>	12.1.25
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue:	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>RF</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 78237
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	211	212		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.502	0.501	0.501	0.501		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.376	0.376		
I	0.490	0.510		0.501	0.501	0.501	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.570	0.570	0.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.126	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.253	0.253		
S	0.115	0.135		0.127	0.127	0.127	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.245	0.245	0.245	0.245		
W	0.115	0.135		0.127	0.127	0.126	0.127		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.366	0.365	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.252	0.252	0.252	0.252		
AE	1.375	1.395		1.385	1.386	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.252	0.252	0.252	0.252		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

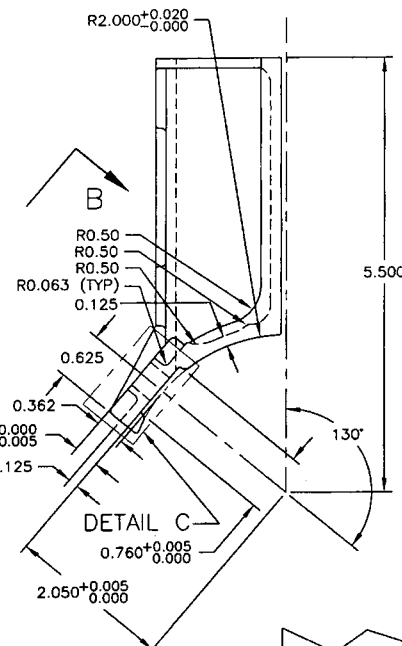
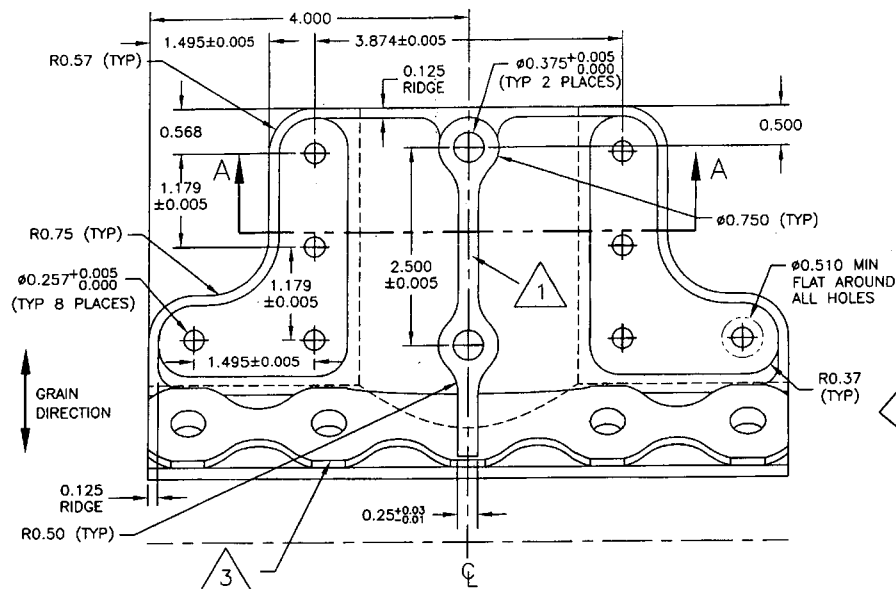
Measured by: B.A
Date: 12/01/24

Audited by: RF
Date: 12-1-25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
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RELEASED

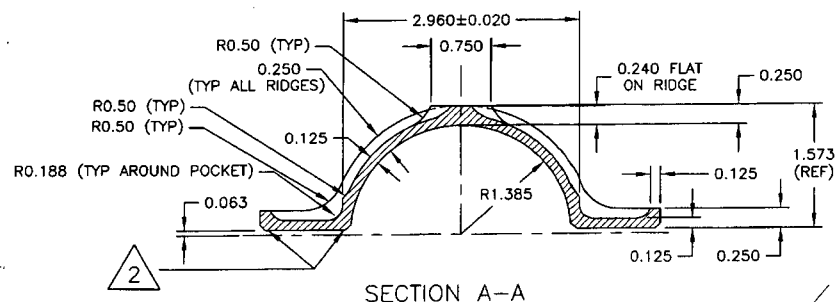
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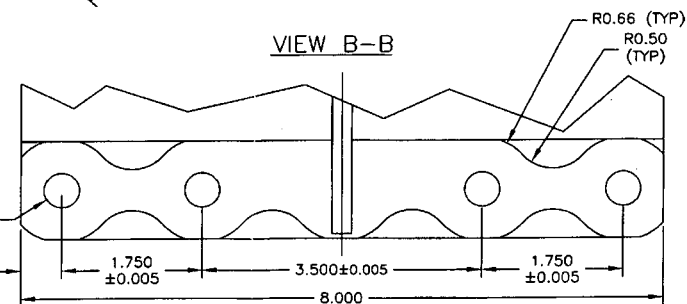
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

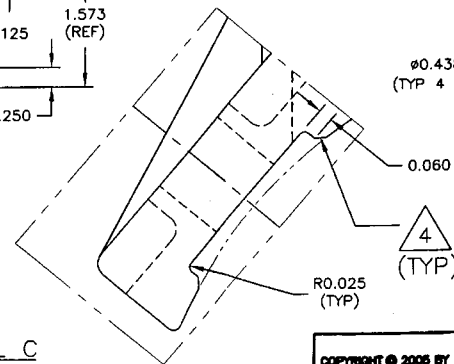
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



SECTION A-A



VIEW B-B



DETAIL C
SCALE 2:1

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NOTICE
NO. 782-37 M.L.J

12/01/02

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE INNER FWD SADDLE
		DART DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
		DRAWING NO. D2572
		REV. E
		SHEET 1 OF 1
		SCALE 2:3

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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries